

Work Order ID 150604

Monday, August 29, 2016 2:46:14 PM

150604

Page 1

Item ID: D3196-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 8/18/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: 16-08-31

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3196

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

INSPECT MATERIAL FOR DEFECTS BEFORE CUTTING

Cut blank: (0.75" x 1.50") x 34.750" long Bar

4

16-9-26

110

0.24

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.30

HAAS CNC vertical machine #1

1-Machine D3196-4 as per Folio FA339 and Dwg D3196Identify as D3196-42-Deburr

4

16-9-26

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

3

1

16-9-26

P.T.O.

DQA:

Date:

JAN 4 2017



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date: OCT 12 2016

Work Order update only ☐

Work Order: <u>150604</u> Part No. <u>3196-4</u> NCR No. <u>16-6092</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																											
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- 1 part is scrap, part was put on wrong side in nics				- scrap + no replace																																																																																																															
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Work Order ID 150604***150604***

Page 2

Monday, August 29, 2016 2:46:14 PM

Item ID: D3196-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 8/18/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						3	0		DAS 14 9-29
QC	Memo	0.01							16/10/02
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						(x3)	0		2016/10/03
HandFinish	Memo	0.07							BEB
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150						3	0	16-10-3	14 9-29
Powdercoat	Memo	0.02							
Powder Coating	START TIME: 3:10 FINISH TIME: 3:40								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, August 29, 2016 2:46:14 PM

Page 1

Work Order ID: 150604

150604

Parent Item: D3196-4

D3196-4

Parent Item Name: Bar

Start Date: 8/18/2016

Required Date: 8/29/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	16.0105	2.89	12.16842			

M6061T6B0 750X01 500

6061-T6 Bar .750 X 1.50

**

169-26

Location

Loc Qty

Loc Code

MAT

16.0105

134284

0.52

m131700

2.7905

m134984

0.7

m135247

12

135559

12.0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 150604
Description: Bar		Part Number: D3196-4
Inspection Dwg: D3196	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	/		MM-TAPE	
33.650	+/-0.010	33.649	/			
16.639	+/-0.010	16.639	/			
0.488	+/-0.010	.488	/		VERN	SL-10
0.962	+/-0.005	.962	/			
0.464	+/-0.010	.463	/			
0.504	+/-0.010	.503	/			
Ø0.344	+0.006/-0.001	.344	/			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	.660x100°	/			
0.512	+/-0.005	.513	/			
0.060 x 45°	+/-0.010 x 0.5°	.06x45°	/			
4.750	+/-0.010	4.749	/			
12.531	+/-0.010	12.531	/			
16.627	+/-0.010	16.627	/			
21.844	+/-0.010	21.844	/			
29.625	+/-0.010	29.625	/			
0.250	+/-0.010	.250	/			
1.000	+/-0.010	1.001	/			
R0.125	+/-0.010	R.125	/			
0.987	+/-0.010	.986	/			

Measured by: JH	Audited by: DAS	Preliminary Approval:
Date: 16/9/26	Date: 16/10/22	Date:

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev updated	KJ/JLM	
C	11.06.21	Dwg Rev updated	KJ	

DART

RELEASED

06.10.31

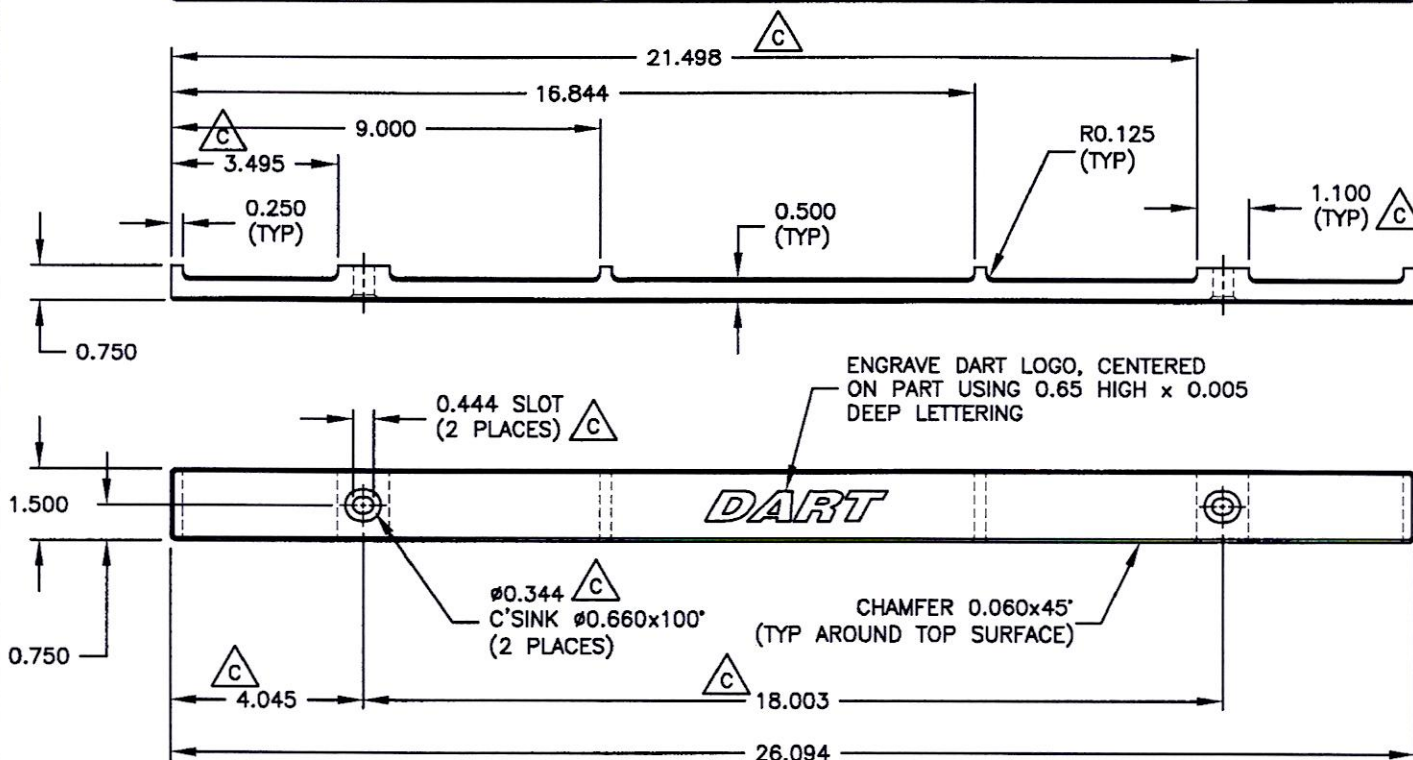
DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150604 MJS
16-08-31

CHAMFER 0.060x45°
(TYP 6 PLACES)

ENGRAVE P/N CENTERED
ON PART USING
0.15 HIGH x 0.005 DEEP
LETTERING

R0.125
(TYP)



D3196-1 BAR

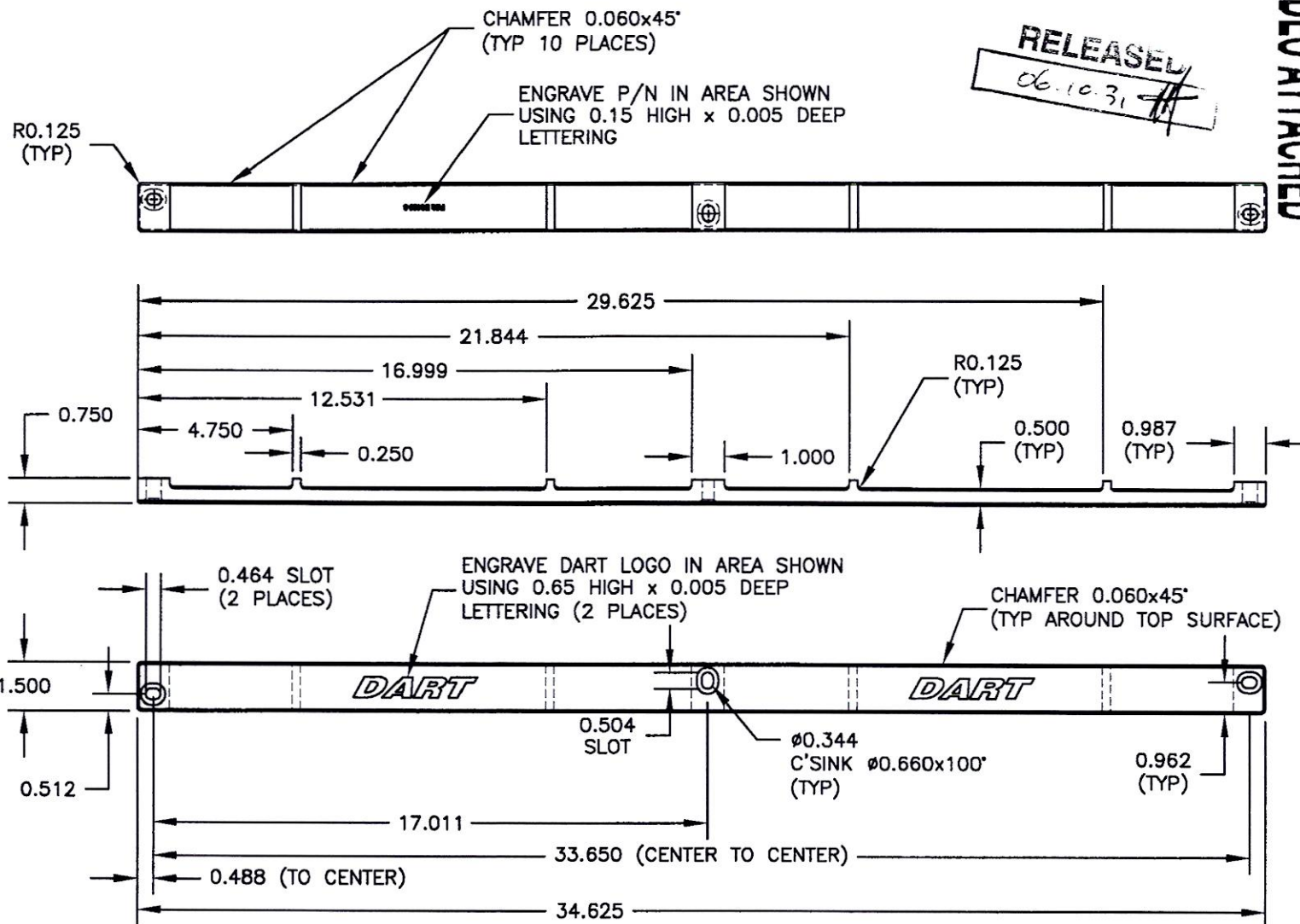
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
06.10.31	03.06.25	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
06.10.31	06.09.25	D3196
DATE	TITLE	SHEET 1 OF 3
06.10.31	BAR	SCALE
A	NEW ISSUE	1:4
B	ADD D3196-5	
C	ADD SLOTS ON -1; REMOVED -5	

DART

DETACHED

RELEASED
06.10.31



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
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DESIGN	DRAWN BY	DART AEROSPACE LTD
06	06	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
06	06	D3196
DATE	TITLE	SHEET 2 OF 3
06.10.31	BAR	SCALE
		1:5

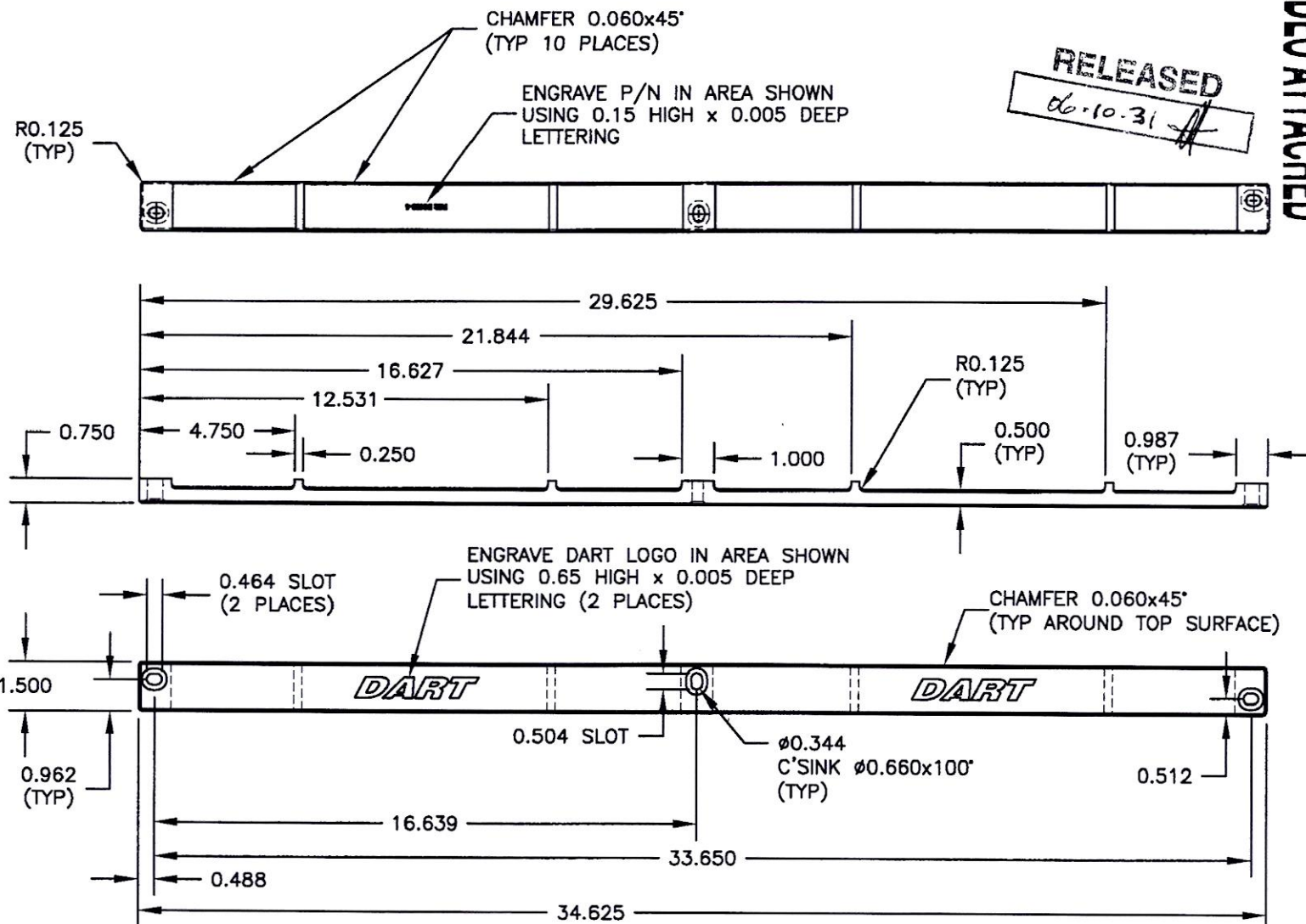
DART

DETACHED

RELEASED

06-10-31

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
06.10.31	D3196	SHEET 3 OF 3
	TITLE	SCALE
	BAR	1:5

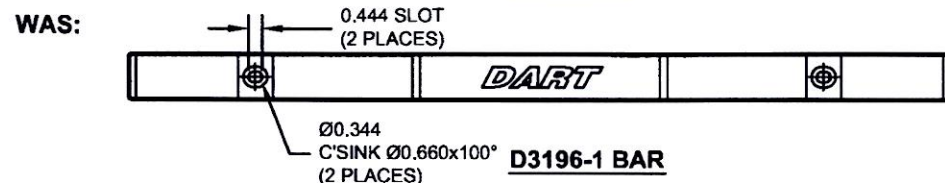
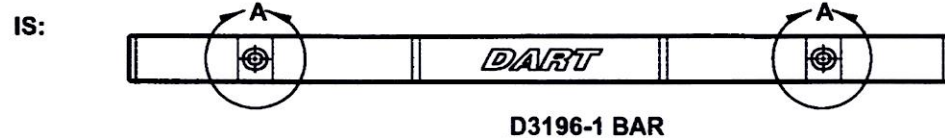


D3196-4 BAR

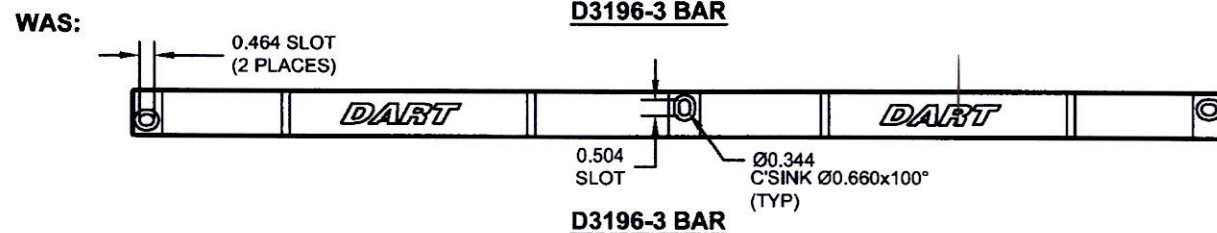
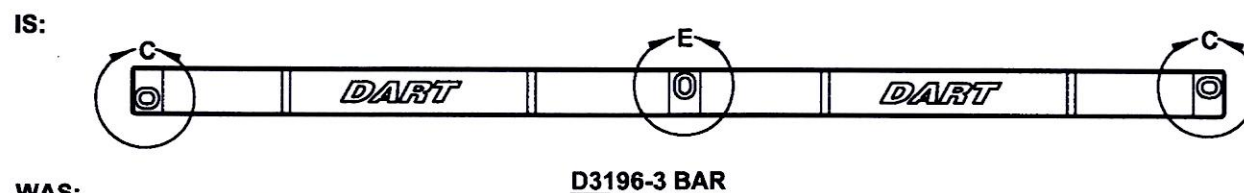
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DRAWING NO. D3196	TITLE BAR	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3196-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04	

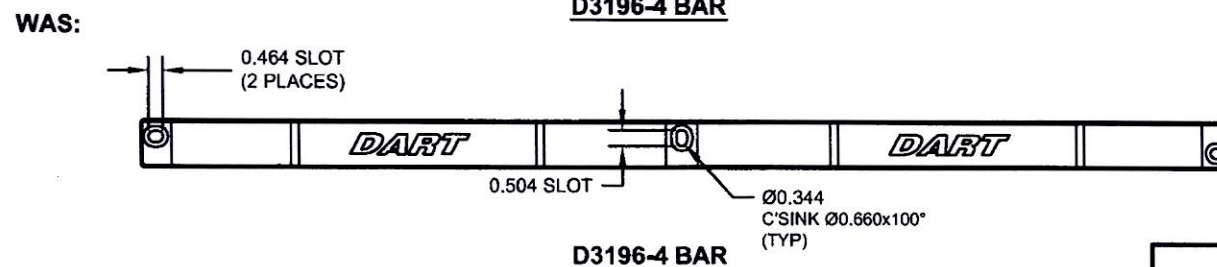
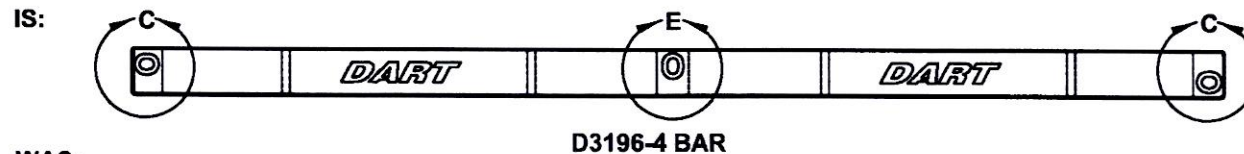
SHEET 1 MODIFY SLOT DIMENSIONING ON D3196-1 AS SHOWN:



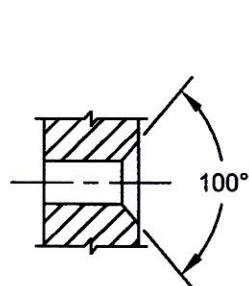
SHEET 2 MODIFY SLOT DIMENSIONING ON D3196-3 AS SHOWN:



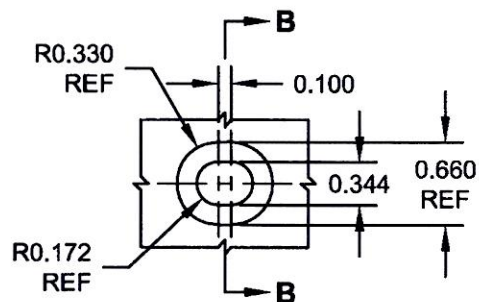
SHEET 3 MODIFY SLOT DIMENSIONING ON D3196-4 AS SHOWN:



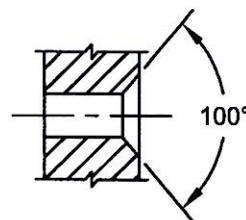
DRAWING NO. D3196	TITLE BAR	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3196-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04		



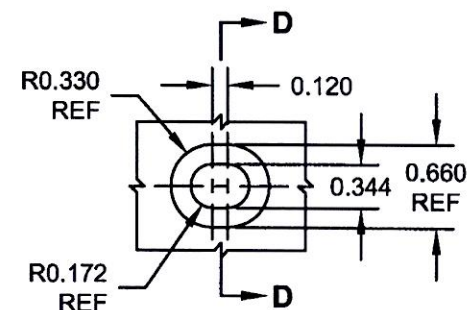
SECTION B-B



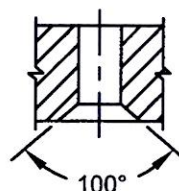
DETAIL A



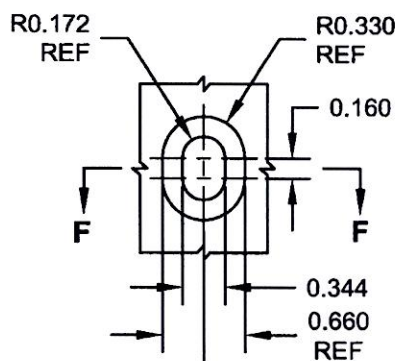
SECTION D-D



DETAIL C



SECTION F-F



DETAIL E

NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS
SEE NCR 08-051 FOR FURTHER INFORMATION
ALL OTHER INFORMATION REMAINS UNCHANGED

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